

Date: Wednesday, 04/06/2008 12:36:43 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 39698	
Estimate Number : 10706	
P.O. Number :	Part Number : D2012103
This Issue : 04/06/2008 S.O. No. :	Drawing Number : D2012-103 REV B2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B2
Previous Run : 37296	Material :
Written By :	Due Date : 11/06/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUL 08.6.04</u>	
Comment : Est Rev: 02.04.03 Added Inspect level 3 NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 3.5700 f(s)/Unit Total: 35.7000 f(s)
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)
 Identify as D2012-101
 Batch: M108215

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch to length as per Dwg D2012-103 & template D2012-103T1(41.00")

SB 08/06/04

(10)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SB 08/06/10

(10)

2-Bend D2012-103 as per template D2012-103T2 & Dwg D2012-103

FF 08-06-12

(10)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/06/12 (10)

5.0	POWDER COATING	POWDER COATING
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M102316



(10X)

Comment: POWDER COATING.

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

1:40 P.m

M.A

08/06/12

td

WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 04/06/2008 12:36:43 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 39698

Part Number: D2012103

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE:

FINISH TIME:

320 °F
2:10 Pm

M-L 08/06/12
(10x)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/12
(10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P 08/06/13
(10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/16
(10)

Job Completion



U 08.06.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

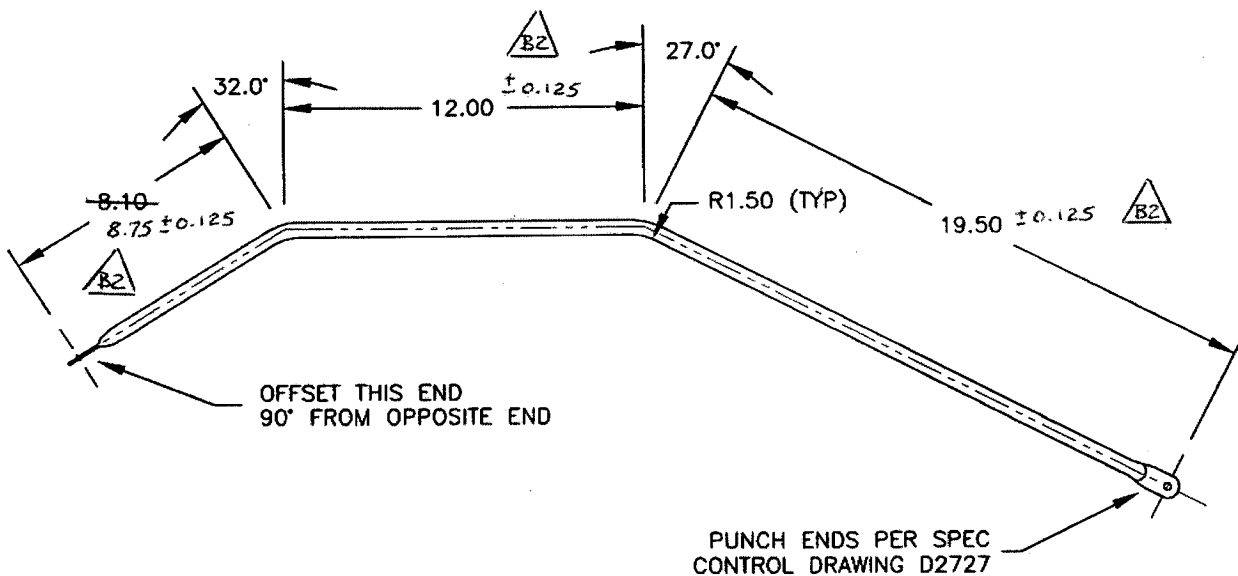
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
98/05/05 Kc

DESIGN		DRAWN BY		DART AEROSPACE LTD	
KE		KE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	MM	APPROVED	JS	DRAWING NO.	REV. B
DATE		98.04.28		D2012-103	SHEET 1 OF 1
				TITLE	SCALE
				ARM	1:6
A		92.06.08		NEW ISSUE	
B		98.04.28		CHANGE ANGLES (TSR A362)	
B1		02.03.25		ADD FINISH	
B2		05.04.27		ADD TOLERANCE: PINS WAS 8.10	

**NOTES:**

1. MAKE PER TEMPLATE DT8068 (WAS DT2012-103)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.500 x 0.035 WALL
3. FINISH: POWDER COAT BLACK SANDTEX (4,5,7) PER DART QST 43

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21012

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries